	er ID 74723 ober 05, 2011 1:50		· · · · · · · · · · · · · · · · · · ·									Page	1
Item ID: Revision ID:	D3209-041			Accept					Setup	Start			
•	Bracket Assembly		·	•						Stop			
Start Date: Required Date:		art Qty: 6.00 q'd Qty: 6.00	.		Cust It		The Company						
Reference:		<i></i>		1. 1					_	C : 1	1 (88)(10) 81	!!!# {#! #! ##!	ı
Approvals:	Process Plan:	M.L.J N	Date: 11 10 05	Tooling:		Date:			Run	Start			ļ
	QC:		Date:	SPC (Y/N):		Date:				Stop			
Sequence ID/ Work Center ID		eration cription		Set Up/ Run Hours	Tool	ID Tool	# Plan Code	Accept Qty	Rejo Qty		Reject Number	Insp. Stamp	
Draw Nbr	Revision	Nbr											
D3209	Rev A												
100 Bandsaw	ВАМ	ND SAW		0.00			•						_
Jeaspa Bandsaw		Cut blanks:	1.500" x 1.250" x 1.950" lo	ng Bar (+0.030/-0.000	SL 11-	10-06	· • .s	<u>(6)</u>	- · · · · · · · · · · · · · · · · · · ·		*	⁷⁰ 00,	š
110 HAAS I	HAA	AS CNC VERTICA	L MACHINING #1	0.00	of)	1 F.K. 1	1/10/	5 , &	4	A.			P
HAAS CNC vertical	machine #1	Memo Machine D □ Deburr and	3209-1 as per Folio FA345 a		ify as D3209-1					•			
120	QC2	, 2- Inspect parts off r	nachine FAI/FAIB	0.00	K_ 111	10/11		5	1	l		٠.	
QC		Memo		0.00	- /	- / //					,		-

Memo

Quality Control

W/O:		74 723 WORK OF	DER CHANGES				~
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		.~					
				<u> </u>		<u>L.</u>	

NCR:		wo	ORK OR	DER NON-CONFORMANCE	: (NCR)	NJ:26 XJ =	95.12	
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Section B Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector
11/10/11	100	Blank was to short R.L. cut in som how Short. hora.	Sulvoliz aszan	+ SCRAPER QH +1 .	11/10/	S. Nicol12	S 11/10/12 057012	Sulializ
Miliola	100	too short. Should be 1. 820" But measured 1. 838" QL. Pirt Nort. Place ween	Th. 10.12	Scrapt Desty + no replace Ohx1	1110/2	S ulwl12	Thorz	Culusha
		into se operator essor						

Wai	rk	Ord	er	ID	74723
*****	I.M.	VIU	CI	w	/ 4 /43

Wednesday, October 05, 2011 1:58:47 PM



Page 2

Item ID:

D3209-041

Accept

Setup Start



Revision ID:

Item Name:

Bracket Assembly

Start Date: Required Date: 10/14/2011

10/5/2011

Start Qty: 6.00

Req'd Qty: 6.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

Stop

Stop

QC:

Date:_____ SPC (Y/N):

Date:

Reject Insp.

Sequence ID/ Work Center ID

130

Quality Control

Operation Description

OC8- Inspect parts - second check

Memo

Set Up/ Run Hours

0.00

0.00

B.A 11/10/13

Tool ID

Tool # Plan Code

Accept Qty

Reject Qty

Number Stamp

140

HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

150

Powdercoat

Powder Coating

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

Memo

0.00

Note: Cover the hold for D3209-1 before powder coat.

START TIME:

OVEN TEMPERATURE:

XD Mif 14/10/1

W118484

W/O: WORK ORDER CHANGES										
DATE	STEP	PR	OCEDURE CH	IANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
			•							
Part No	:	PAR #:	Fault Ca	tegory:	NC	R: Yes	No DQ	A :	_ Date: _	
	R	esolution:	Disposit	ion:	QA	: N/C CId	sed:		Date: _	
NCR:			WORK OR	DER NON-CONFORM	IANCE	(NCR)			
DATE	STEP	Description of NC		*································	ction B		Verific	cation	Approval	Approval
DAIL	JILI	Section A	Initial Chief Eng	Action Description Chief Eng	371-V	Sign & Date		on C	Chief Eng	QC Inspector
						:				
				, , , , , , , , , , , , , , , , , , , ,						
		·								
	1		l			1		_		1

Required Date: 10/14/2011



Page 3

Item ID:

D3209-041

Wednesday, October 05, 2011 1:58:47 PM

Accept

Setup Start

Stop



Revision ID:

Start Date:

Item Name:

Bracket Assembly

10/5/2011

Start Qty: 6.00

Req'd Qty: 6.00



Date: _____

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Date:

Run Start

Reject

Qty

Stop



Sequence ID/ **Work Center ID**

160

Quality Control

Operation Description

QC3- Inspect Part Finish

Memo

Set Up/ **Run Hours**

0.00

SPC (Y/N):

0.00

Tool ID

Tool # Plan

Code

Accept

Qty

Reject Number

Insp. Stamp

161

Small Fab

Small Fab

170

Memo

press fit bushing as per dwg

QC5- Inspect part completeness to step on W/O

0.00

0.00

SB 11/10/17

QC

Quality Control

Memo

0.00

0.00

W/O:			V	WORK ORDER CHANG	ES				
DATE	STEP	PROC	EDURE CH	IANGE	Ву	C	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
	i								
Part No:		PAR #:	Fault Ca	tegory:	_ NCR: Ye	es No	DQA:	Date: _	<u> </u>
		esolution:							
NCR:		W	ORK OR	DER NON-CONFORMA	ANCE (N	CR)	× 24	1844	
DATE	STEP	Description of NC		Corrective Action Section			Verification	Approval	Approval
		Section A	Initial Chief Eng	Action Description Chief Eng		n & ite	Section C	Chief Eng	QC Inspector
		·							
NOTE 5	<u> </u>								

Work Order ID 74723

Wednesday, October 05, 2011 1:58:47 PM



Page 4

Item ID:

D3209-041

Accept



Setup Start



Revision ID:

Item Name:

Bracket Assembly

Cust Item ID:

Stop

Start Date:

10/5/2011

Required Date: 10/14/2011

Start Qty: 6.00 Req'd Qty: 6.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



Date:

SPC (Y/N):

Date:

Stop

Sequence ID/

Work Center ID

180

Packaging

Operation Description

Identify as per dwg & Stock Location:

Set Up/ **Run Hours**

0.00

Tool ID

Tool# Plan Code

Accept Qty

Reject Qty

Reject Number

Insp. Stamp

Packaging

Memo

0.00

190

QC21- Final Inspection - Work Order Release

0.00



Quality Control

Memo

0.00

W/O:			VV	ORK ORDER CHAN	IGES				<u>r</u> .		
DATE	STEP	PRO	CEDURE CH			Ву	Date Qt	Approval Chief Eng / Prod Mgr	Approva QC Inspector		
·			· .								
Part No);	PAR #:	Fault Cate	egory:	NCI	R: Yes I	No DQA:	Date:			
	. A	esolution:	Disposition	on:	QA:	QA: N/C Closed: Date:					
NCR:		W	ORK ORD	ER NON-CONFORM	ANCE	(NCR)					
DATE	STEP	Description of NC	Corrective Action Section B				Verification	Approval	Ammunusi		
		Section A	Initial Chief Eng	Action Description Chief Eng) 	Sign & Date	Section C	Chief Eng	Approval QC Inspector		
	·]			,							
	,										
NOTE :						×.					
MOIE: D	ate & initia	al all entries					L	_L			

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

Picklist Print

Wednesday, October 05, 2011 1:58:52 PM

Work Order ID: 74723

Parent Item:

D3209-041

Parent Item Name: Bracket Assembly



Start Date: 10/5/2011

Required Date: 10/14/2011

Page 1

Start Qty: 6.00

Required Qty: 6.00

Comments:

A□04.06.09□New issue□KJ/RF□

					•								
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3209-3 		Manufactured	No			100	Each	34.0000	1	J)	(/ / i i	17	
				Location	<u>l</u>	Loc	<u>Oty</u>	Loc Code	/				
				ST041			34			· ***	_		
					40930		34		_	5	_		
16061T6B1.500X01.25		Purchased	No			170	f	12.1120	0.175	1.105263	3		
0 										<u> </u>	-06		4
				Location	<u>l</u>	Loc	<u>Oty</u>	Loc Code					
				MAT004	ļ	1	2.112		_		_		
				•	118071		0.112		_		_		

12

118400

Dart	Aeros	pace	Ltd
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W/O:			/ W'	ORK ORDER CHAN	GES				<u>e : </u>
DATE	STEP	PROC	EDURE CHA	ANGE		Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
							•		
		 ·					₹		
Part No	•	PAR #:	Fault Cate	egory:	NCR	R: Yes N	o DQA:	Date:	
		esolution:							
NCR:		W	ORK ORD	ER NON-CONFORM	IANCE	(NCR)			
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Se Action Description Chief Eng	ction B	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector
				·		2010			
_									
		·							
					:				
						×.			

DART AEROSPACE LTD	Work Order:	71723
Description: Bracket	Part Number:	D3209-1
Inspection Dwg: D3209 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X	First Article		Prototype
---	---------------	--	-----------

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.675	+/-0.005	.670	7		VernFk-04	
1.850	+/-0.010	1.840	7		1 11	
R0.40	+/-0.030	e41	7	_	Н	
0.725	+/-0.005	557,	1		1,000	
0.800	+/-0.010	-80Z	7		41	
1.125	+/-0.010	1,122	1		17	
Ø0.375	+0.001/-0.000	.375	1		ท	
0.180	+/-0.010	, I77	7		ħ	
R0-13	+/-0.030	13 3886	7		rad gauge	
0.180	+/-0.010	.182	7		Vern FKai	·
0.854	+/-0.010	.860	7		1)	
,						

Measured by:	6K. lart	Audited by:	BA	Prototype Approval:	N/A
Date:	11/10/11	Date:	11 10 13	Date:	N/A

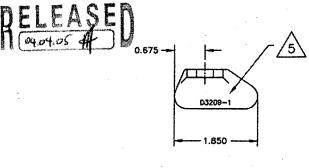
Re	v Date	Change		Revised by	Approv <i>e</i> d_
Α	05.02.17	New Issue	(P/O D3209-041)	KJ/JLM OK	
				(")	

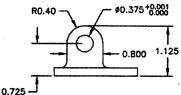
W/O:		WORK ORDER CHANGES									
DATE	STEP	PROC	EDURE CH	IANGE	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
			c								
Part No	•	PAR #:	Fault Ca	tegory:	_ NCR: Yes	No DQA:	Date: _				
Resolution:		esolution:	Disposition: QA: N/C Closed: Date:								
NCR:		Wo	ORK OR	DER NON-CONFORMA	ANCE (NCF)					
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Section Action Description Chief Eng	on B Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector			
							·				
,			-								





	DESIGN	DRAWN BY		OSPACE LTD ONTARIO, CANADA
	CHECKED	APPROVED	DRAWING NO.	REV. A
l	91	I SW	D3209	SHEET 1 OF 1
ı	DATE		TITLE	SCALE
	04.01.27		BRACKET	1:2
	A	04.01.27	NEW ISSUE	



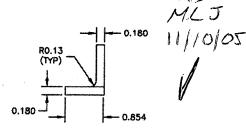


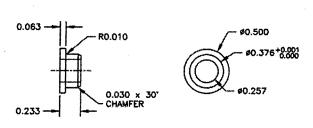


D3209-1 BRACKET



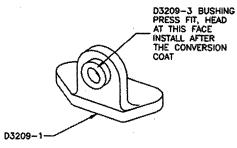
SHOP COPY RETURN TO **ENGINEERING UNCONTROLLED COPY** SUBJECT TO AMENDMENT WITHOUT NOTICE WORK ORDER NO 34723







D3209-3 BUSHING





- D3209-1 BRACKET: D3209-3 BUSHING
 1) BREAK ALL SHARP EDGES 0.005 TO 0.015
 2) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8) ALUMINUM BAR (M6061T6B)
- 3) MATERIAL: AISI 303 SS (M303R) 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
 ENGRAVE DART P/N AS SHOWN
 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 ALL DIMENSIONS ARE INCHES

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Da	rt	A	eı	0	sp	ac	e	Ltd

W/O:	T "	WORK ORDER CHANGES										
DATE	STEP		PROCEDURE CH	EDURE CHANGE			Date	Qty Appro	eng/ Approv			
Part No: PAR #:		Fault Cat	tegory:	NCF	NCR: Yes No DQA:			Date:				
Resolution:			Dispositi	Disposition: QA: N			sed:	Da	_ Date:			
NCR:	· ₁		WORK ORI	DER NON-CONFO	DRMANCE	(NCR)					
DATE	STEP	Description of NC	Initial	Corrective Action Section		Vori		ion Appro	oval Approva	Approval		
		Section A	Chief Eng	Action Descrip	ouon	Sign & Date	Section			or		
78.												
	34											
	1	•										
				,								
								•				
NOTE: Da	to & initis	al all entries										